

a solid center made from a first rubber based material;
a solid outer layer made from a second rubber based material having different physical properties from said first rubber based material;
forming an inner cover layer made from a material having a first shore D hardness and having an outer diameter of at least 1.58 inches;
casting an outer cover layer having a thickness of about 0.05 inches or less made from a material having a second shore D hardness less than the first shore D hardness of the material of the inner cover layer.

- 2 74. (New) The method of claim 73, wherein the outer cover layer has a hardness of about 30 Shore D to about 60 Shore D
- G 75. (New) The method of claim 73, wherein the inner cover layer has a hardness of about 65 to about 74 Shore D.
76. (New) The method of claim 73, wherein the outer cover layer has a thickness of about 0.02 inches to about 0.04 inches.